

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLADE POSITIONER WELDMENT
Job Number	: 40241		
Estimate Number	: 13443		
P.O. Number	:	Part Number	: PB674300129
This Issue	: 7/4/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.40
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: B1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 7/10/2008
Checked & Approved By	:	Qty:	5
Comment	: Est Rev:A 08-06-27 new issue DD verified by:ec	Um:	Each

Job Number:

1.0	PB6743001313	Plate
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Plate

batch:

2.0	PB6743001319	Gusset
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Gusset

batch;

3.0 PB6743001337 Upper Pad Assembly

Upper Pad Assembly

batch:

40 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL. PRIOR TO WELDING****

1- ASSEMBLE AND WELD AS PER DWG

50	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER WELDMENT

Job Number: 40241

Part Number: PB674300129

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/07/21 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2/17/11 08/07/21 (S)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320 OF
2:10

M-1 08/07/21

(S)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/21 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

512

8/7/23 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



mf 08-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

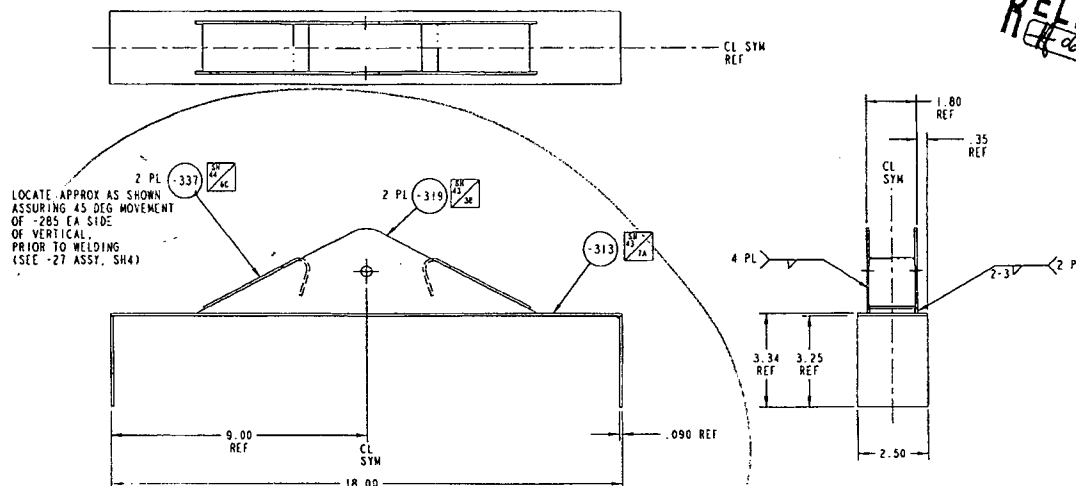
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

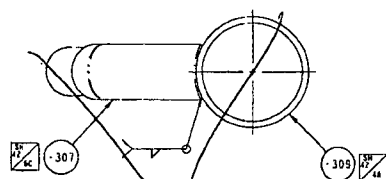
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
#6-11-22



① -29 BLADE POSITIONER WELDMENT
SCALE 0.500

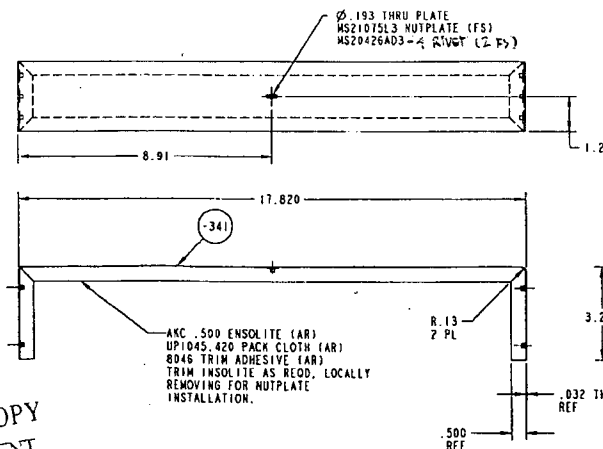


-25 TUBE GUIDE WELDMENT
SCALE 1.000

SUBMITTED BY

DB440-1 & DB440-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
40241



① -35 LOWER PAD ASSY
SCALE 0.500

MATL FOR -341: .032 THK 2024-T3, QQ-A-250/4

PREMIER AVIATION, INC.	
3001 Aviation Parkway, Grand Prairie, Texas 75052	
SIZE: CODE 1041 NO. 1041	REV: 1
DOSUV8	B67-43001
SCALE: 1:1	SHEET: 40 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39952
Description: Blade Positioner Weldment		Part Number:	367-43001-29
Dwg: 367-43001	SHEET 40	Qty:	5
		Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	cut GA WJ	gusset - 319 use mat: 090 6061-T6 al. (m7950), cut 12.00" x 3.00" (mark part out on piece as per drawing) drill hole in center as per drawing. deburr.			2
3	cut GA WJ	plate - 313 & 317 use mat: 090 6061 T6 al. (m7950) make as one part 24.5" x 2.5" (mark out part and bend) deburr			1
4	cut GA WJ	plate - 337 use mat: 090 6061 T6 al. (m7950) cut and mark part for bending & bend as per drawing) deburr			2
5	weld WA	all parts together			
6	drill GA	when inside part is made (material and padding) match match hole on part 1/4" hole 7 holes in total.			
7	chem. FP	chemical conversion OSI 0054.1.			
8	paint FP	powder coat green saterf OSI 0054.3			
9	QC3	Inspect Powder Coat.			
10	SI	Identify & Stock.			
11	QC	Level 21 / Close w/o.			
6B	QC49	Inspect Work / Weld.			
PRELIMINARY ISSUE					

Rev	Date	Change	Revised By	Approved